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(4)

D206-667-247RN
Job Sheet 16821-A



Part No: D206-667-247TRN

Job Qty: 1 ea

Part Name: Crosstube Assembly, Mid Aft



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/30/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV A IPP rev:A 11.01.06 new issue DD ver:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/29/17	11/29/17	0.00	0.00	Start Up Crosstubes		PMP
100	Mori Seiki	1 pcs	11/29/17	11/29/17	3.85	1.33	Mori Seiki TL-40		PMP
110	QC	1 pcs	11/29/17	11/29/17	0.00	0.00	QC2		PMP
120	Mori Seiki	1 pcs	11/29/17	11/29/17	0.00	1.33	Mori Seiki TL-40		PMP
130	QC	1 pcs	11/29/17	11/29/17	0.00	0.00	QC2		PMP
140	QC	1 pcs	11/29/17	11/29/17	0.00	0.00	QC8		PMP
145	Crosstubes	1 pcs	11/29/17	11/29/17	0.00	0.37	Crosstube		2015/01/16 JSC
150	HandFXtube	1 pcs	11/30/17	11/30/17	0.00	0.32	Crosstube		W
160	QC	1 pcs	11/30/17	11/30/17	0.00	0.00	QC7		W
170	Packaging	1 pcs	11/30/17	11/30/17	0.00	0.00	Packaging3		W
180	QC21-SA	1 Ea	11/30/17	11/30/17	0.00	0.00	QC21		W

Part Op 100 - 1-Fill tube with sand & install plugs 206-207 on both ends as per Folio FB030 2-Turn first side as per Folio FB030
Descriptions: 3-Blend transition line with belt sander 60 grit.

120 - 1-Turn second side as per Folio FB030 2-File down transition lines smooth.

145 - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.

150 - 1- handfinish X-TUBE INSIDE AND OUT

170 - LOCATION : LG014

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6004-115	1	46	0	0

B116 116

Part Specifications

Specifications could not be found.

Plex 11/13/17 12:38 PM dart.poulin.mario

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Crosstube Assembly, Mid Aft

PART NO: D206 - 667 - 247TRN
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 11/21/17
Job No: 168213-A

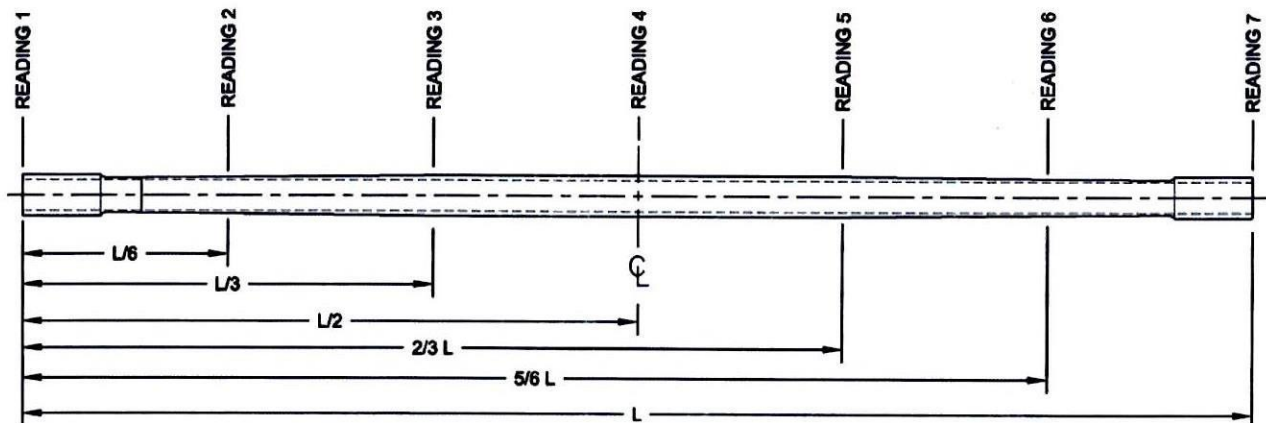
DART AEROSPACE LTD	Work Order:	168213-17
Description: Crosstube Assembly, Mid Aft	Part Number:	D206-667-247
Inspection Dwg: D206-667-247 Rev: A		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.494	✓		VERN 08	
	2.025	+0.005/-0.000	2.029	✓			
	2.079	+0.005/-0.000	2.084	✓			
	2.145	+0.005/-0.000	2.150	✓			
	2.209	+0.005/-0.000	2.214	✓			
	2.287	+0.005/-0.000	2.291	✓			
	2.363	+0.005/-0.000	2.367	✓			
	0.200	+/-0.010	.199	✓		VERN 08	
	R0.063	+/-0.010	.063	✓		RG	
	R2.00	+/-0.010	2.0	✓		RG	
	R0.063	+/-0.010	.063	✓		RG	
	4.438	+/-0.010	4.447	✓		VERN 08	
SIDE B	2.490	+0.005/-0.000	2.494	✓		VERN 08	
	2.025	+0.005/-0.000	2.029	✓			
	2.079	+0.005/-0.000	2.0835	✓			
	2.145	+0.005/-0.000	2.150	✓			
	2.209	+0.005/-0.000	2.2135	✓			
	2.287	+0.005/-0.000	2.291	✓			
	2.363	+0.005/-0.000	2.3665	✓			
	0.200	+/-0.010	.200	✓		VERN 08	
	R0.063	+/-0.010	.063	✓		RG	
	R2.00	+/-0.010	2.0	✓		RG	
	R0.063	+/-0.010	.063	✓		RG	
	4.438	+/-0.010	4.445	✓		VERN 08	
	99.76	+/-0.020	99.765	✓		TAPE	

DART AEROSPACE LTD	Work Order:	
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WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L = 0"	360	355	357	368	.013	0.045"
READING 2 L = 16.63	206	200	202	209	-.009	
READING 3 L = 33.25	350	342	339	349	.011	
READING 4 L = 49.88	364	357	357	366	-.009	
READING 5 L = 66.506	349	339	340	353	-.014	
READING 6 L = 83.133	209	198	200	215	-.017	
READING 7 L = 99.76	359	353	358	368	.015	

Calibration Result

Actual Block Thickness: 200-400

Sitescan 250 Measured Thickness: 201-400

DAS
47

Measured by: <u>PMP</u>	Audited by: <u>9-89</u>	Preliminary Approval:
Date: <u>2017-11-16</u>	Date: <u>17-12-28</u>	Date:

Rev	Date	Change	Revised by	Approved
A	11.06.21	New Issue	KJ	
B	12.02.02	Dimension 4.438 was 4.500	KJ	
C	12.06.01	Wall thickness form added	KJ	